

# Work Order ID 56748 - 2

March 8, 2010 9:14:52 AM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

7

Stop



Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 09/03/2010 Req'd Qty: 8.00

Customer:

Reference:

Jul 10.03.08

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

7

0

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No

56748

Double check by:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

MWF

10/03/10

110

0.00



CONVENTIONAL MILLING MACHINE

7

0

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

DTA 10/03/11

# Work Order ID 56748

March 8, 2010 9:14:52 AM



Page 2

Item ID: D2572	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Fwd In 205					
Start Date: 09/03/2010	Start Qty: 8.00		Cust Item ID:		
Required Date: 09/03/2010	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	M/W= 10/03/10 DTP 10/03/11			7	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	B.A 10/03/15			7	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	J 10/03/16			17	0		

# Work Order ID 56748

March 8, 2010 9:14:52 AM



Page 3

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 09/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:20pm ☐  
OVEN TEMPERATURE: 370°F ☐  
FINISH TIME: 2:50pm

=> JU 10/03/16

(X7)

Ø

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OK 10-3-16

(7)

Ø

170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

Picop/R2 (7)

**Work Order ID 56748**

March 8, 2010 9:14:52 AM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 09/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 DJ

mf

10-3-22

# Picklist Print

March 8, 2010 9:14:52 AM

Page 1  
7

Work Order ID: 56748



Parent Item: D2572



Parent Item Name: Saddle, Fwd In 205

Start Date: 09/03/2010

Required Date: 09/03/2010

Comments: IPP: ☐ 02.10.02 ☐ Re-format; Change to Dwg Rev. D & incorporated  
D2572 ☐ KJ ☐

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	106.0000	8.0000			
Saddle Billet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46411

106

106

MMF  
10/03/09

8 #40

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 56748
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.751	1.747	1.747	1.747		
C	3.495	3.505		3.498	3.498	3.499	3.500		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.003	8.004	8.004	8.004		
F	0.490	0.510		.501	.508	.499	.500		
G	0.257	0.262		.260	0.259	0.259	0.259		
H	0.375	0.380		.377	0.377	0.377	0.377		
I	0.490	0.510		.501	.497	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.566	.544	.562		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.126	0.126	0.125	0.126		
Q	0.115	0.135		.130	.135	.135	.123		
R	0.240	0.260		.250	0.248	0.249	0.249		
S	0.115	0.135		.130	0.130	.129	.128		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.957	2.958	2.958	2.960		
V	0.230	0.250		.241	0.241	.235	.236		
W	0.115	0.135		.121	.127	.128	.125		
X	0.307	0.312		0.315	.310	.309	.309		
Y	0.760	0.765		0.761	.760	.761	.761		
Z	0.352	0.372		.360	.363	.360	.361		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.617	.627	.616	.616		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	0.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.389	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	0.255	0.255	0.255		
AH	0.240	0.260		.248	0.248	.248	.249		
AI	2.000	2.020		2.002	2.000	2.005	2.003		
AJ	0.023	0.043		0.033	.033	.035	.035		
Accept/Reject									

Measured by:	DTJ / MW
Date:	10/03/11 / 10/03/15

Audited by:	H.A
Date:	10/03/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>56748</b>
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>	


Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

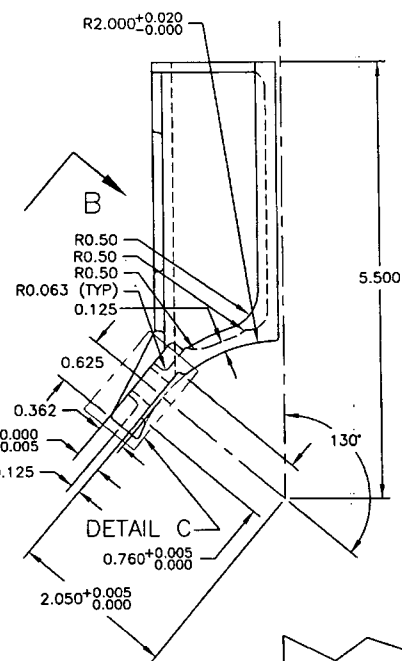
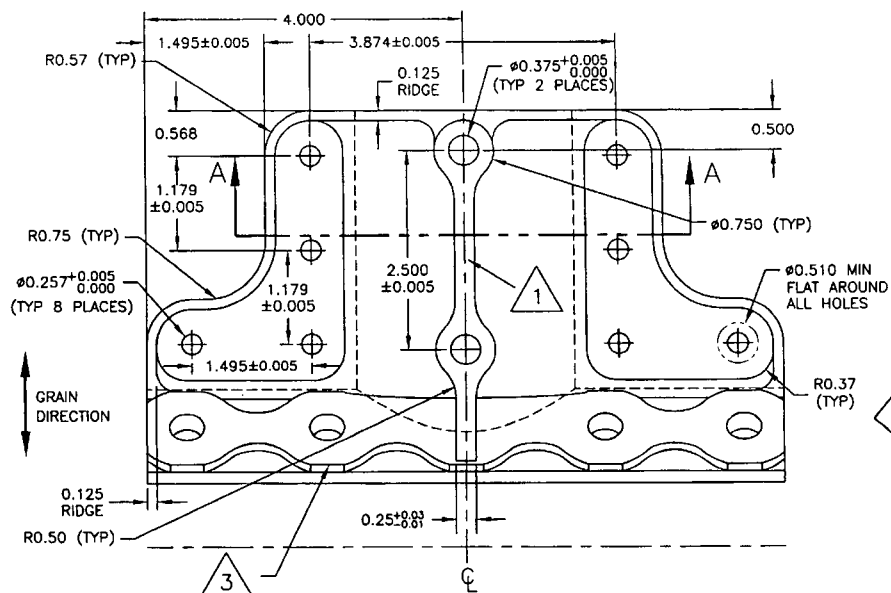
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	4	By	Date
A	0.438	0.443		.440	.440	.440			
B	1.745	1.755		1.747	1.747	1.747			
C	3.495	3.505		3.499	3.500	3.500			
D	1.745	1.755		1.747	1.747	1.747			
E	7.990	8.010		8.004	8.004	8.004			
F	0.490	0.510		.500	.498	.500			
G	0.257	0.262		.260	.259	.260			
H	0.375	0.380		.377	.377	.377			
I	0.490	0.510		.498	.499	.498			
J	1.174	1.184		1.180	1.180	1.180			
K	0.558	0.578		.565	.566	.566			
L	1.174	1.184		1.180	1.179	1.180			
M	1.490	1.500		1.495	1.495	1.495			
N	2.495	2.505		2.500	2.500	2.500			
O	3.869	3.879		3.874	3.874	3.875			
P	0.115	0.135		.124	.125	.123			
Q	0.115	0.135		.135	.135	.135			
R	0.240	0.260		.250	.247	.248			
S	0.115	0.135		.125	.127	.125			
T	0.178	0.198		.188	.188	.188			
U	2.940	2.980		2.956	2.955	2.957			
V	0.230	0.250		.234	.236	.236			
W	0.115	0.135		.125	.127	.130			
X	0.307	0.312		.310	.310	.310			
Y	0.760	0.765		.761	.761	.761			
Z	0.352	0.372		.357	.357	.357			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.615	.615	.617			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.250	.250	.250			
AE	1.375	1.395		1.387	1.389	1.389			
AF	0.115	0.135		.135	.135	.135			
AG	0.240	0.280		.248	.246	.246			
AH	0.240	0.260		.249	.250	.250			
AI	2.000	2.020		2.007	2.007	2.006			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

Measured by:	<i>MM</i>
Date:	10/03/15

Audited by:	<i>H.A</i>
Date:	10/03/15






Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

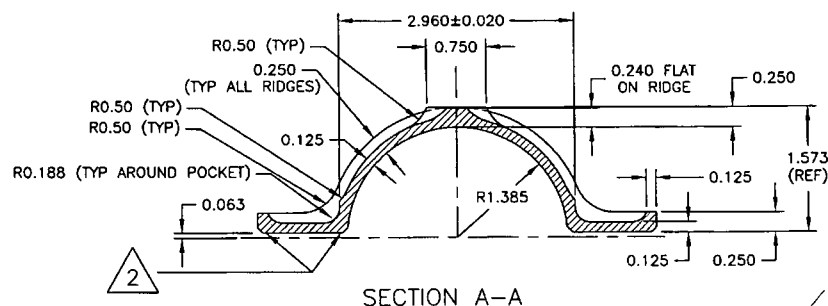
05.12.06 



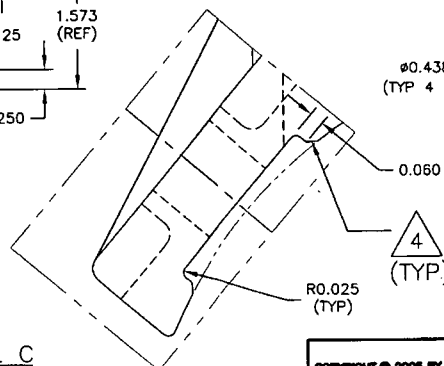
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

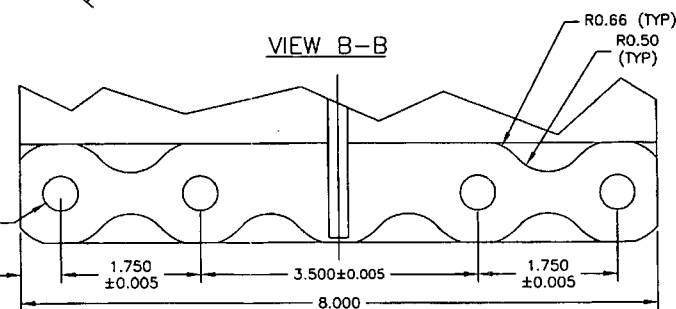
- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |
-  E












SECTION A-A



DETAIL C  
SCALE 2:1



VIEW B-B

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4												
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES												
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177												
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425												
A	96.09.16	NEW ISSUE												
<table><tr><td>DESIGN DS</td><td>DRAWN BY PH</td><td></td><td>DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA</td></tr><tr><td>CHECKED </td><td>APPROVED </td><td>DRAWING NO. D2572</td><td>REV. SHEET 1 OF 1</td></tr><tr><td colspan="2">DATE 05.07.13</td><td>TITLE INNER FWD SADDLE</td><td>SCALE 2</td></tr></table>			DESIGN DS	DRAWN BY PH		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	CHECKED 	APPROVED 	DRAWING NO. D2572	REV. SHEET 1 OF 1	DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE 2
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DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE 2											

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